January-	24-	13	11:57:	30	AM

Item ID: D3237-3-0980

Accept \*N900040100\*

Setup Start

Page 1

Item Name: Seal

**Revision ID:** 

Start Date:

1/24/13

**Start Oty: 10.00** Rea'd Otv: 10.00 \*10\* \*10\*

Cust Item ID:

Customer:

Reference:

Approvals:

Required Date: 2/07/13

Process Plan: ML5 Date: 13-01-2 Tooling:

Revision Nbr

Date:

QC: \_\_\_\_\_ Date: \_\_\_\_ SPC (Y/N):

Date:

Sequence ID/ Work Center ID Operation Description Set Up/ Run Hours

Tool ID

Tool # Plan Accept Qty Code

Reject Qty

Stop

Run

Reject Insp. Number Stamp

Draw Nbr D3237

Rev B

100 \*100\*

Small Fab

Small Fab

Small Fab

Memo

0.00

0.00

Cut as per dwg D3237 (98" long)

110

QC5- Inspect part completeness to step on W/O

\*110\*

Memo

Quality Control

120

Identify as per dwg & Stock Location:

0.00

\*120\*

Packaging

Memo

0.00

Packaging

NCR:	Yes	/ No					WORK ORDER NON-C	ON	NFORM	MANCE / UPDA		۰ -	Data	
					1		Γ	-1				QA Closed:	Date:	
Work Ord	er:					_	DISPOSITION				AGAINST DEF	PARTMENT/	PROCESS  Water Jet	Engineering
Part l	No.					_	Rework Scrap Use-as-is		ľ	Skid-tube Machining oforming	Crosstube Small Fab Finishing		d. Eng. Coor.	Quality Other
NCR	No.			· ·		_	Work Order Update			~ <b>—</b>	Composite	Nec/3ton	Supplier	Other
Root	-			ļ	De	escri	ption of work order update		nitial	Actio	n	Sign &		
Cause		Date	Step	Qty		·	or Non-conformance	Ch	ief Eng	Descrip	tion	Date	Verification	QC Inspector
oc/Data quip/Tooling perator flaterial etup other rocess upplier raining						3 3 4								
napproved														
					1		F <i>i</i>	AUL	T CATE	ORY				
Landi	ng (	Gear					General		1			1	_	7
	Bending Centre Not Concentric to O/S Cracks Crushed/Crimped Cuffs			O/S		Bend BOM/Route Broken/Damaged Burrs Contamination		Instruct Mainte	on Incomplete ons Incomplete/Un nance	clear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved	ssing	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled	
Heat Treat			-	Countersink	$\vdash$	Mislabe			Positioned W		Other			
		Inspection Ripples in		fube		-	Cut Too Short Drill Holes	$\vdash$	Misread Offset		<u> </u>	Power Loss/S	ourge	Tottlei
	<del> </del>	1		vtrusio	,	-	Drawing	-	ł	alibration			***************************************	
Torque Waves in Extrusion		$\vdash$	Finish		Out of Sequence									

Outside Dimensions

DQA:

Date:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

QC

Quality Control

January-24-13 11:57:30 AM Item ID: D3237-3-0980 Accept \*N900040100\* Setup Start **Revision ID:** Item Name: Seal **Start Date:** 1/24/13 **Start Qty: 10.00** \*10\* **Cust Item ID:** Required Date: 2/07/13 Req'd Qty: 10.00 **Customer:** Reference: Run Start Process Plan: Date: Approvals: Tooling: Date: Stop \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool # Plan Accept Reject Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 130 QC21- Final Inspection - Work Order Release 0.00 \*130\*

0.00

Memo

MLJ 13-05-29

NCR: Y	es / No					WORK ORDER NON-C	CON	NFORN	AANCE / UPD	ATE	QA Closed:	Date	<u>.</u>
Work Orde	er:					DISPOSITION				AGAINST DE		/PROCESS	
Part N	lo				_	Rework Scrap Use-as-is		r	Skid-tube Machining noforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor. e/Packaging	Engineering Quality Other
NCR N	lo				-	Work Order Update			Large Fab	Composite	]	Supplier	
Root	-			Dę	scri	ption of work order update		nitial	Acti	on	Sign &		
Cause	Date	Step	Qty		(	or Non-conformance	Ch	ief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data													
quip/Tooling												٠.	
Operator													
Material		1											
Setup													
Other													
Process							1						
Supplier													
Training													:
Unapproved			<u> </u>	<u> </u>							<u></u>	<u> </u>	
							AUL	T CATE	GORY				
Landir	ng Gear				_	General	_	1		<del></del> -	<b>.</b> .	Г	
	Bending				<u> </u>	Bend	$\vdash$	Grain			Ovalized	<b> </b>	Pressure/Forced
	Centre N	ot Conce	ntric to	O/S	<b>—</b>	BOM/Route	_	Hardwa		ļ	Over/Under	<u>-</u>	Temperature/Cure
	Cracks				$\vdash$	Broken/Damaged			on Incomplete	_	Part Incorre	<b>⊢</b>	Weld
	Crushed/	Crimped.	-			Burrs	-		ions Incomplete/U	Inclear	Part Lost/M	issing [	Wrong Stock Pulled
	Cuffs				<u> </u>	Contamination	$\vdash$	Mainte		_	Part Moved		
	Heat Trea				$\vdash$	Countersink	<u> </u>	Mislabe		<u> </u>	Positioned V		
	Inspectio	•	Tube		-	Cut Too Short		Misread	i	L	Power Loss/	Surge	Other
	Ripples in					Drill Holes	$\vdash$	Offset	- 10				
	Torque V			n	<u> </u>	Drawing		1	Calibration				
	Turning Sequence					Finish	Out of Sequence						

Outside Dimensions

Date:

DQA:

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID: 96347

Parent Item:

D3237-3-0980

Parent Item Name: Seal

\*96347\*

\*D3237-3-0980\*

**Start Date: 1/24/13** 

Required Date: 2/07/13

**Start Qty: 10.00** 

Required Qty: 10.00

**Comments:** 

IPP REV:A 11.04.26 as per dwg rev.B DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	ı
D3237-3		Manufactured	No			100	f	329.5126	8.166 <b>6</b>	85.96421	, <u> </u>			
*D3237-3*									*tel	13	15/20	<u>} /</u>	100	)

Location Loc Qty ST407\_ 329.512642 329.512642

Loc Code

Page 1

NCR: Y	es / No					WORK ORDER NON-O	O	<b>IFORN</b>	/IANCE / UPI	DATE			
	·										QA Closed:	Date	:
Work Orde	r:				_	DISPOSITION					PARTMENT	والمنافق المنافق المنا	, ,
Part N	lo					Rework Scrap		Skid-tube Crosstube  Machining Small Fab			-4	Water Jet d. Eng. Coor e/Packaging	Engineering Quality Other
NCR N	lo.				_	Use-as-is Work Order Update	]		noforming Large Fab	Finishing Composite	Rec/stor	Supplier	
Root		[		De	scri	ption of work order update		nitial	Act	tion	Sign &		
Cause	Date	Step	Qty		(	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC inspector
Doc/Data			**	1									
quip/Tooling											1	٠.	
Operator [		1											
Material [													
Setup [													
Other													
Process							İ						
Supplier													
Training													
Unapproved		1					<u> </u>						
,						F	AUL	T CATE	GORY	<u></u>			
Landir	ng Gear			1		General						_	_
	Bending				Ŀ	Bend		Grain			Ovalized	L	Pressure/Forced
	Centre N	ot Conce	ntric to	o/s		BOM/Route		Hardware			Over/Under	tolerance	Temperature/Cure
ļ	Cracks					Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct _	Weld
	Crushed/	Crimped		1	Г	Burrs		Instruct	ions Incomplete/l	Unclear	Part Lost/M	issing	Wrong Stock Pulled
ſ	Cuffs					Contamination		Mainte	nance		Part Moved		
1	Heat Trea	at				Countersink		Mislabe	led		Positioned V	Vrong	
Inspection Strip in Tube			- 1		Cut Too Short		Misread	i		Power Loss/	'Surge	Other	
Ì	Ripples in	n Bend				Drill Holes		Offset					
1	Torque W	Vaves in I	Extrusio	n		Drawing		Out of 0	Calibration				
Ţ	Turning S			-		Finish		Out of S	Sequence				
Wave/Twist in Tube						Folio		Outside	Dimensions				

DQA: \_\_\_\_\_ Date: \_\_\_\_

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

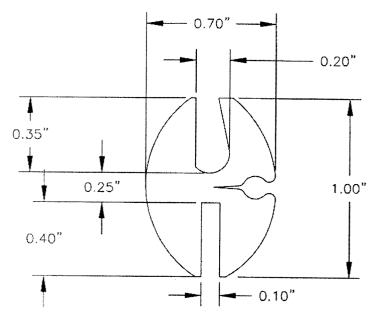




DESIG	*#	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KEDM	APPROVED	DRAWING NO. REV. B
	11	1 H	D3237 SHEET 1 OF 1
DATE			TITLE SCALE
04.0	)5.05		SEAL
Α		04.01.22	NEW ISSUE
В		04.05.05	REMOVE (REF) & ADD QSI 018



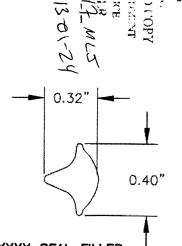
## SPECIFICATION CONTROL DRAWING



## D3237-1-XXXX SEAL RETAINER

WHERE 'XXXX' IS LENGTH IN TENTHS OF INCHES EG. 98.0" LONG EQUALS D3237-1-0980

PURCHASE: MILL SUPPLY, INC. P/N R-1025 TOLERANCES PER DART QSI 018 UNLESS OTHERWISE **SPECIFIED** 



WHERE 'XXXX' IS LENGTH IN TENTHS OF INCHES EG. 98.0" LONG EQUALS D3237-3-0980

PURCHASE: MILL SUPPLY, INC. P/N R-1029 TOLERANCES PER DART QSI 018 UNLESS OTHERWISE **SPECIFIED** 

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